

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008275**Date Inspected:** 23-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng and Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 3AW near crossbeam. The weld designations reviewed are as follows:

1. SEG013D-074, 083, 138, 137, 164, 173, 075, 076, 084, 085, 129, 130, 138, 139, 128, 137
2. SEG013E-031, 023, 032, 033, 165, 166, 031, 049
3. FB017-001-128, 012~020
4. FB021-001-128, 013~019
5. FB025-001-128, 013~019,
6. SSD010A-PP20-170, 168, 174, 177, 166, 172
7. SSD011A-PP21-168, 166, 167, 172, 164, 165
8. SSD012A-PP22-169, 172, 173, 177, 178, 170, 171
9. SSD022A-PP20.5-169
10. SSD022A-PP21.5-170
11. BP025-001-25~43

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1AAW Segment

SMAW welding of spacer blocks at various locations on side plate (crossbeam side of segment).

Welder is identified as Mr. Tian Zhaoquan (045246). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113-FCM-1.

1AW Segment

FCAW welding of weld joint 003 located on SSD34A-PP8.5.

Welder is identified as Mr. Ren Linsheng (207465). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-Repair-1.

2BE Segment

SMAW repair welding of side plate stiffeners located at panel point 18 (bike path side).

Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

SMAW repair welding of side plate stiffeners located at panel point 18 (crossbeam side).

Welder is identified as Mr. Lv Peng (048617). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1.

4AE Segment

FCAW repair welding of weld joint 004 located on SSD20-PP025.

Welder is identified as Mr. Wang Xingjian (051356). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-FCM-Repair-2 and CWR procedure B-CWR629.

FCAW repair welding of weld joint 004 located on SSD20-PP025.

Welder is identified as Mr. Wu Wanyong (050242). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-FCM-Repair-2 and CWR procedure B-CWR629.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
